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(54) LASER WELDING METHOD

(57) Abstract

PURPOSE: To obtain a weld zone having a small crater part with thorough penetration by decreasing the output of laser light and changing the distance between a condenser system and a material to be worked to blur the focus thereof in the stage of ending welding by a set program.

CONSTITUTION: A laser weld line and the end point of welding are preliminarily programmed. The laser light

transmitted from a laser oscillator is condensed and is irradiated on the weld zone of materials to be welded. The materials to be welded are driven and are welded by said light. The distance between the laser light condensing part and the weld zone are increased or decreased to blur the focus of the laser light and to decrease the irradiation intensity at the terminal end of welding just prior to the end of laser welding. The output of the laser light is decreased or stopped at the same instant.

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